

Work Order ID 79106

Friday, January 20, 2012 9:12:13 AM

79106*Ship today* Page 1

Item ID: D2803-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 1/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

*CMF*Date: *12-1-20*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 and D2809 into arm as per Dwg D2803

EB 12/01/20 (1)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

*8-26-20**(46)*
242

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

*9-45**10-15**3200F**M11A480**1X4 M/L 12/01/20*

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Start Date: 1/20/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

1 BB 12-1-20

150

Small Fab

0.00

150

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D2803.

① FF 12-01-20

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

S12/01/20

④
242

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Item ID: D2803-042

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket Assembly

Start Date: 1/20/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/20/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

12/1/2011 (12)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

OK 12/1/20

MR
12-01-20

Picklist Print

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Page 1

Work Order ID: 79106

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 1/20/2012

Required Date: 1/20/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C16A Bolt		Purchased	No			150	Each	64.0000	2	2		FF 12-01-20	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST352	64						
						115835	1						
						118422	4						
						118628	17		2				
						119641	42						
D2803-2 Bracket		Manufactured	No			100	Each	3.0000	1	1		FF 12/01/20	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST148	3						
						71569	1		1				
						75223	2						
D2805-2 Stop		Manufactured	No			100	Each	7.0000	1	1		FF 12/01/20	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	7						
						76186	7		1				
D2809 Bushing		Manufactured	No			150	Each	31.0000	1	1		FF 12-01-20	
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						GA	7						
						72735	7						
						ST018	24						
						34035	12		1				
						77292	12						

Picklist Print

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Work Order ID: 79106

Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 1/20/2012

Required Date: 1/20/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-3 Purchased No 150 Each 1,217.0000 2 2 FF 12-01-20

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	72	
103691	72	
ST300	606	
<u>119901</u>	606	2
ST301	539	
118077	2	
118614	441	
118686	30	
119758	66	

NAS1515H3

Purchased No

100 Each 151.0000 4 4

Washer

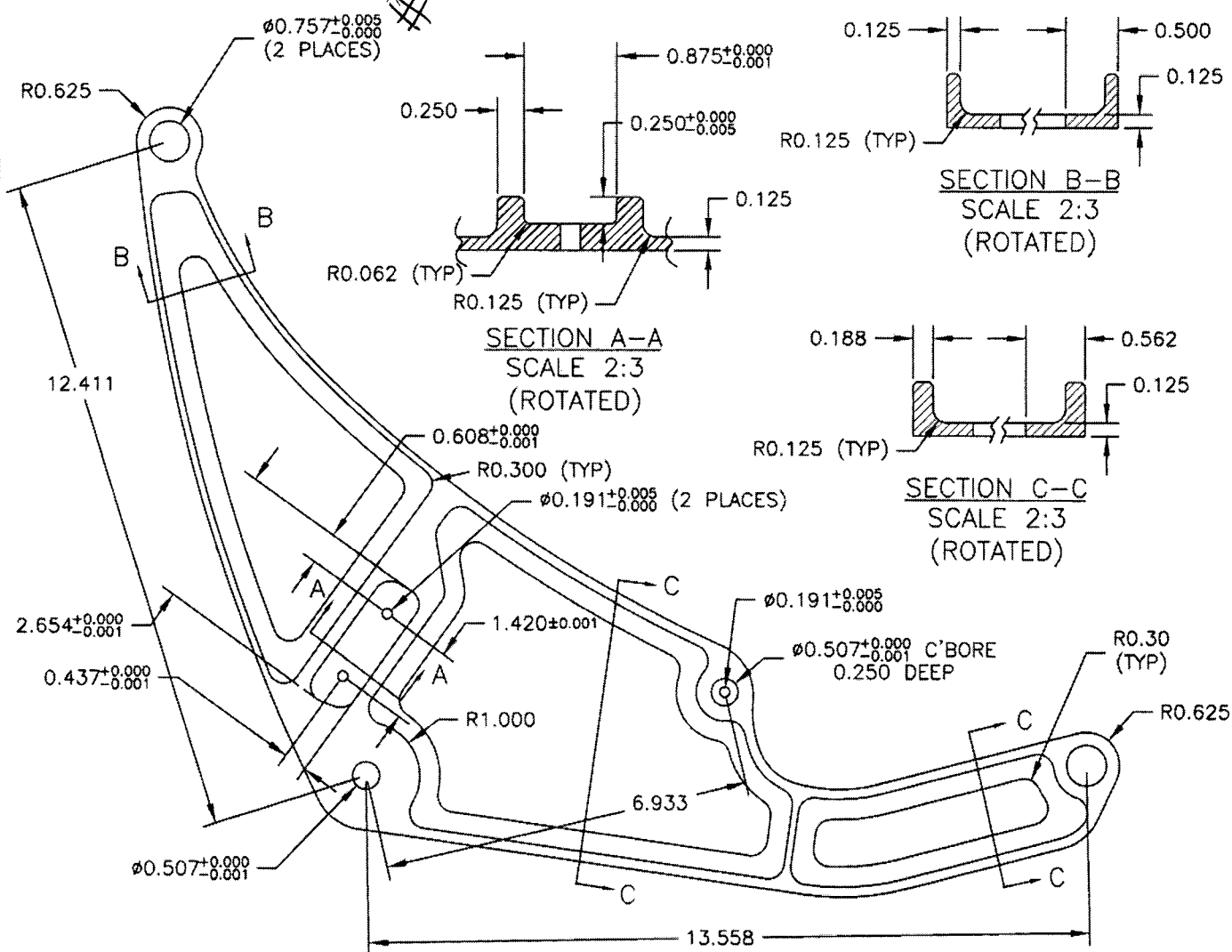
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST277	151	
<u>116373</u>	6	4
118078	6	
118384	11	
119438	28	
120142	100	



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11

**D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)**

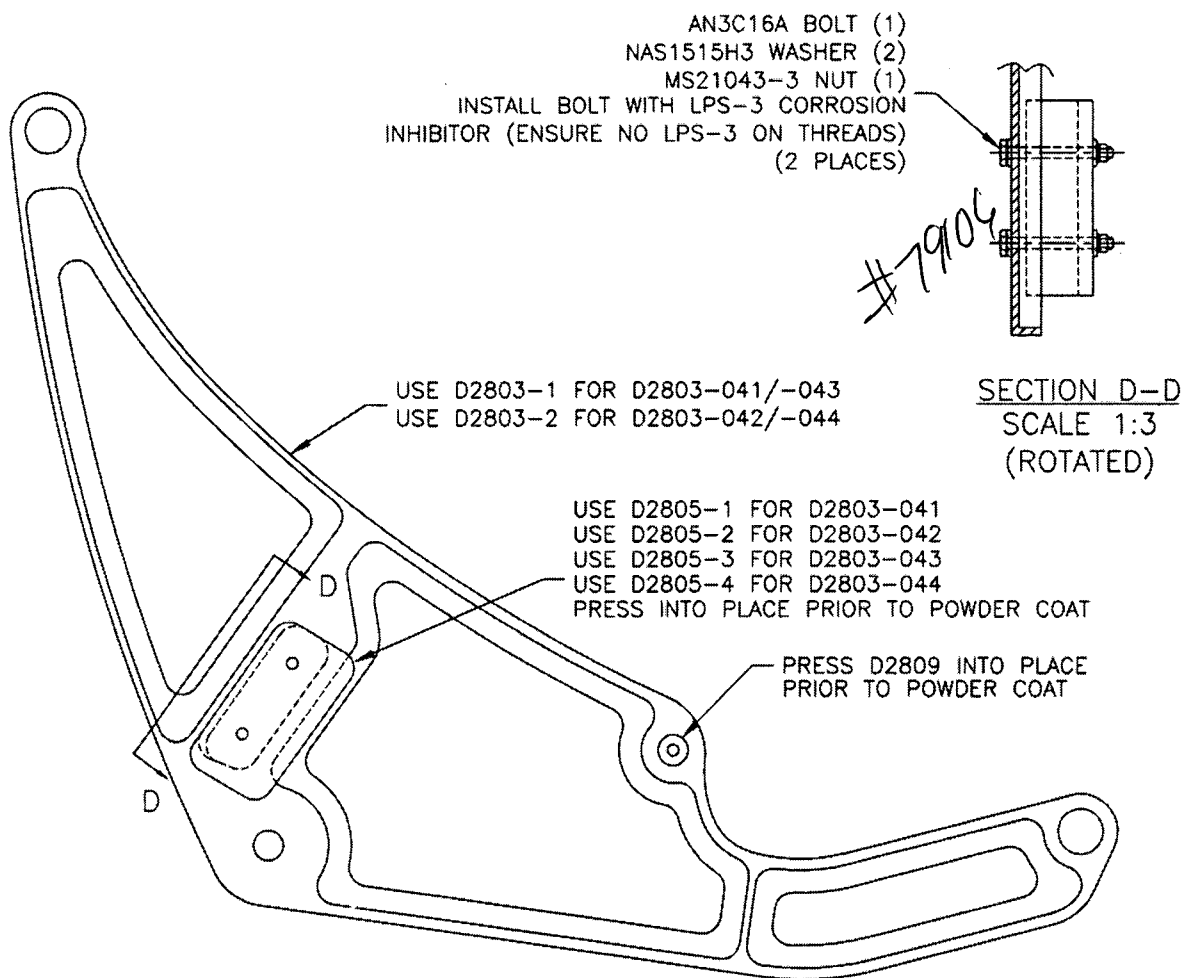
- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2803
				REV. B
DATE	04.11.22	TITLE	STA 84 BRACKET	SHEET 2 OF 2
				SCALE 1:3



RELEASED

05.03.11 #

D2803-041/-043 BRACKET ASS'Y (SHOWN).
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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